

Work Order ID 148875

Tuesday, July 12, 2016 8:51:49 AM

148875

Page 1

Item ID: D2463 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 1/2" Seal (\$Per Foot)
 Start Date: 6/30/2016 Start Qty: ~~100.00~~ **500** ***100*** Cust Item ID:
 Required Date: 7/12/2016 Req'd Qty: ~~100.00~~ ***100*** Customer:
 Reference:

Approvals: Process Plan: DAS Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 21 Date: JUL 13 2016 SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2463	B

100 PURCHASING 0.00 **DAS**
100 **13**
 Purchasing **9-89**

Memo **500** **9102 11 701**
 Issue P/O: **33027** **JUL 14 2016**
 Purchase part as per Dwg D2463 Possible Supplier: Accurate Rubber
 P/N: 451500007

Material release note required

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110
 Packaging Memo 0.33
 Packaging Ensure Material Release Note is attached **500 8/16-7-19**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148875

Tuesday, July 12, 2016 8:51:49 AM

148875

Page 2

Item ID: D2463

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 1/2" Seal (\$Per Foot)

Start Date: 6/30/2016 Start Qty: 100.00

100

Cust Item ID:

Required Date: 7/12/2016 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							DAS 38 9-89
Quality Control									JUL 20 2016
130	Identify as per dwg & Stock Location: <u>St409</u>	0.00							
130									
Packaging	Memo	0.17							DAS 8 9-89
Packaging									JUL 21 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.67							DAS 21 9-89
Quality Control									JUL 22 2016

DAS
21
9-89 JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

Tuesday, July 12, 2016 8:51:49 AM

Page 1 / 1

Work Order ID: 148875

148875

Parent Item: D2463

D2463

Parent Item Name: 1/2" Seal (\$Per Foot)

Start Date: 6/30/2016

Required Date: 7/12/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: B99.02.18Changed Inspection LevelDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
451500007		Purchased	No			100	f	0.0000	1	100			
451500007									**	500			
Seal										500			

500
500 8p/6-7-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

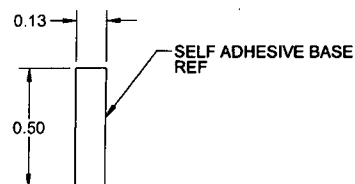
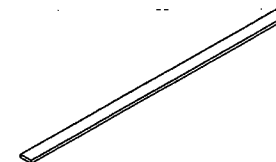
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148875 ML5
16-07-13

SPECIFICATION CONTROL DRAWING



8 LENGTH
XXX.X
+/- 1.0

D2463-XXXX NEOPRENE SEAL $\triangle$ B

DART P/N	MATERIAL	COLOR	DUROMETER	SPEC	WEIGHT (lbs) (PER LINEAR FOOT)	PREFERRED SUPPLIER	SELF ADHESIVE BASE (Y/N)
D2463-XXXX	CLOSED CELL NEOPRENE	BLACK	N/A	MIL-R-6130	0.04	ACR GROUP (ACCURATE RUBBER)	Y

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE
- 8) PART NUMBER DEFINITION: D2463-XXXX
XXXX = LENGTH IN INCHES
EG: D2463-0875 = 87.5 INCHES LONG

RELEASED
2016-05-04
EEN 16-571

APPROVED

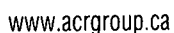
B	REFORMATTED, REDRAWN, MATERIAL CLARIFIED. SEE PAR14-323	AJS	14.12.18
A	NEW ISSUE	KE	98.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	DB	DRAWING NO. D2463	
MFG. APPR.	DD		
APPROVED	WM	TITLE NEOPRENE SEAL	
DE APPR.	DS		
DATE	14.12.18	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REV. B

SHEET 1 OF 1

SCALE

NTS



Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

CUSTOMER COPY

PACKING SLIP 00157930

CUSTOMER NO. 10750

PST#

TO

TO

DATE		SHIP VIA		TERMS			
07/15/16		FED-EX O/N		ACR GROUP INC. NET 30 DAYS			
PURCHASE ORDER NUMBER			DATE ORDERED		SALES PERSON		
P033027			07/14/16		00157930 ROB		
QUANTITY			ITEM NUMBER	DESCRIPTION	UNIT	UNIT PRICE	AMOUNT
ORDERED	SHIPPED	B.O.					
10	10	✓	451500007	✓ 1/8" X 1/2" C.C. EPDM SPONGE ADH. BACK (50' / ROLL) 24R. / CS.	RO		
				Sp/6-7-19			
FED-EX ACCT# 151793240						SUBTOTAL	
						HST	
FREIGHT: Collect				TOTAL AMOUNT			

*Quality Rubber Products To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Molded and Extruded Rubber Products, Cast Polyurethane Specialties*



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33027

Purchase Order Date 7/14/2016 7:51:38 AM

PO Print Date 7/14/2016

Page Number 1 of 2

Order From :
ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

VC-ACR001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 14 2016

Contact Name
Vendor Phone 604 274 9955

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	451500007 AS PER DWG D2463 REV. B B148875	Seal	8/4/2016 Yes 8/4/2016		500.00 f	\$1.33	\$662.70
Line Total:							\$662.70
2	71401-45 Procurement Quality Clauses A005 RIGHT OF ENTRY A013 SHELF LIFE CONTROLLED MATERIAL; 80% SHELF LIFE REQUIRED AT RECEIPT A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS	PROCUREMENT QUALITY CLAUSES	8/4/2016 No 8/4/2016		1.00 Each	\$0.00	\$0.00

PO Instructions: Fedex Acc#151793240

Note:

7/14/2016



12771 No. 5 Road
Richmond, B.C. V7A 4E9
Canada
Telephone : (604) 274-9955
Fax : (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 2016-07-15

Customer : Dart Aerospace LTD

Customer P.O. # : PO33027

Specification: N/A

Customer Ref.# / Stock # : D2463

Serial # : N/A

ACR W.O. # : 157930

Item # : 451500007

Item Description: 1/8" x 1/2" x 50' CC NEO Sponge C/W PSA

ACR Compound : SCE 41

Date Shipped: July 15, 2016

Carrier: _____ B / L : _____

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Michael Reilander

(ACR GROUP INC. REPRESENTATIVE)